

Work Order ID 162867

162867

Page 1

Friday, June 16, 2017 8:12:04 AM

Item ID: D4131-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Front Plate
 Start Date: 6/20/2017 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 6/30/2017 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUN 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4131	C

100		0.00						DAS 14 9-89	
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100

Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

110

QC
Quality Control

Memo

0.12

(2) SC 17/06/21

(2) SC 17/06/21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.24				<u>2</u>			DAS 38 9-89 JUN 22 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION: WA001	0.00 0.12				<u>12</u>		JUN 22 2017	DAS 9-89
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.20							17/6/27 40 DAS 21 9-89 JUN 22 2017

DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

Friday, June 16, 2017 8:12:02 AM

Page 1

Work Order ID: 162867

162867

Parent Item: D4131-1

D4131-1

Parent Item Name: Front Plate

Start Date: 6/20/2017

Required Date: 6/30/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	117.8099	0.1807	2.282526			
M304S18GA									**				
304/316 .050 Sheet													

DAS
14
8-09 **17/06/21**

Location	Loc Qty	Loc Code
MAT020	117.0059	
M135779	7.12	
M136036	6.95	
M136568	17.2959	
M136687	2.24	
M136790	19.4	
M137481	64	
MAT20	0.804	
M134580	0.804	

2.3

DQA: _____ Date: _____

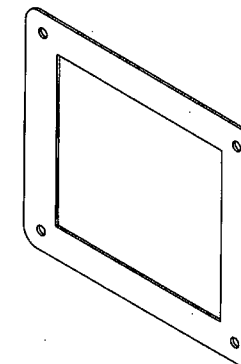
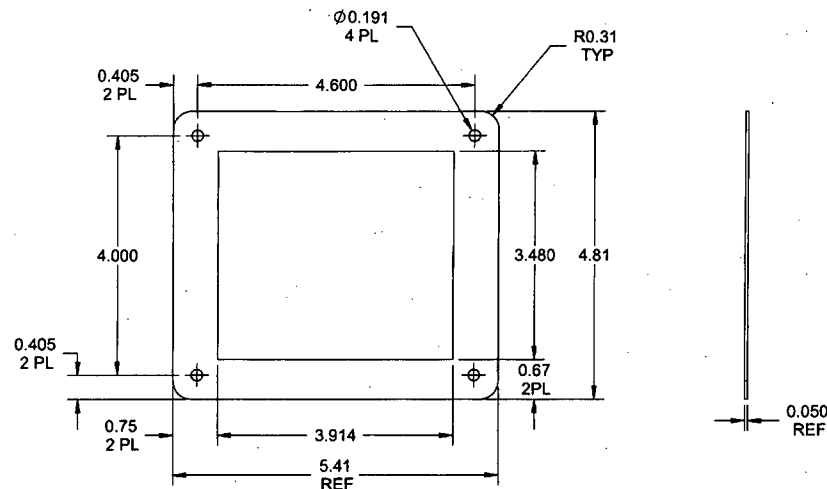


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OTHER : ☐					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 162867 HWS
1 Feb-16

D4131-1 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

RELEASED
2014-10-20

APPROVED	DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 5 OF 10
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
	DATE	14.09.08	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	